Work Order ID 107996

107996

October-07-13 9:06:05 AM

Item ID: D3296-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Replacement Interior Door For -111

Start Date: 10/07/13 **Start Qty:** 6.00 *6*
Required Date: 10/07/13 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-10-08 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3296	B								
100	Small Fab	0.00				6		13/10/23	DAS 36 9-89
100									
Small Fab	**Memo**	0.00							
Small Fab	Fabricate & assemble as per Dwg D3296: Tranfer drill using DT8470 & DT9521								
110	QC5- Inspect part completeness to step on W/O	0.00 SHD 13 10 23				6			
110									
QC	**Memo**	0.00							
Quality Control									
120	Black Sandtex (Ref 3.5.7) per QSI005 4.3 M117358	0.00				6	6	13-10-24	DAS 34 9-89
120									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 10:35 OVEN TEMPERATURE: 200 FINISH TIME: 12:05								

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 107996

October-07-13 9:06:05 AM

107996

Item ID: D3296-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Replacement Interior Door For -111

Start Date: 10/07/13 **Start Qty:** 6.00 *6*

Required Date: 10/07/13 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00				6x	0	11 4	10/ 2x
130									
QC	**Memo**	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	**Memo**	0.00				6x			13/10/24 DAS 36 9-89
Small Fab	Assemble as per Dwg D3296								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	**Memo**	0.00				6			
Quality Control									

Ship 13 10 24

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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Work Order ID 107996

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Item Name: Replacement Interior Door For -111

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Required Date: 10/07/13 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST218	0.00							
160						6X	DAS 28 9-89	13-10-28	
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170							13-10-28		
QC	**Memo**	0.00					YMF		
Quality Control								13-10-28	

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

October-07-13 9:06:04 AM

Work Order ID: 107996
Parent Item: D3296-041
Parent Item Name: Replacement Interior Door For -111

Start Date: 10/07/13 **Required Date:** 10/07/13
Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2137 Decal(No Step)		Manufactured	No			140	Each	20.0000	1	6		13/10/24	DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				GA		20							
				102952		4							
				103583		10					6		
				90854		6							
D2419 Handle		Manufactured	No			140	Each	6.0000	1	6		13/10/24	DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				GA		6						B108030 (6)	
				105347		6							
D2462 Seal $Per Foot		Manufactured	No			140	f	396.4654	2.8166	16.8996		13/10/24	DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				ST403		396.4654							
				48530		13.7336							
				98802		382.7318					16.8996		
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	8.0000	1	6		13/10/23	DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				ST031		8						B108079 (6)	
				102989		4							
				105376		4							
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	8.0000	1	6		13/10/23	DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				ST031		8						B108134 (3)	
				103094		7					3		
				95970		1							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
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- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

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- ☐ Contamination
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- ☐ Drill Holes
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- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
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- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

October-07-13 9:06:04 AM

Work Order ID: 107996

Parent Item: D3296-041 **Start Date:** 10/07/13 **Required Date:** 10/07/13

Parent Item Name: Replacement Interior Door For -111 **Start Qty:** 6.00 **Required Qty:** 6.00

D3296-1 Door Panel	Manufactured	No		100	Each	18.0000	1	6	13/10/23 DAS 36 9-89

Location		Loc Qty	Loc Code	
GA		2		
	99754	2		
ST233		16		
	106194	16		6

D3296-3 Door Panel	Manufactured	No		100	Each	16.0000	1	6	13/10/23 DAS 36 9-89

Location		Loc Qty	Loc Code	
ST233		16		
	105327	16		6

MS20470AD4-4 Rivet, Universal Head	Purchased	No		140	Each	5,274.0000	25	150	13/10/24 DAS 36 9-89

Location		Loc Qty	Loc Code	
GA		1		
	121652	1		
ST336		5273		
	116188	68		
	118614	135		
	122027	188		
	m125807	1166		150
	m126275	3716		

MS20470AD4-6 RIVET, UNIVERSAL HEAD	Purchased	No		100	Each	785.0000	1	6	13/10/24 DAS 36 9-89

Location		Loc Qty	Loc Code	
GA		3		
	118927	3		
ST336		751		
	125654	751		6
ST505		31		
	123021	31		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

October-07-13 9:06:04 AM

Work Order ID: **107996**

Parent Item: **D3296-041**

Parent Item Name: Replacement Interior Door For -111

Start Date: 10/07/13 **Required Date:** 10/07/13

Start Qty: 6.00 **Required Qty:** 6.00

NAS1149DN632J Washer	Purchased	No		140	Each	557.0000	1	6	13/10/24 DAS 36 9-89

Location		Loc Qty	Loc Code	
ST293		546		
	123900	5		
	M126084	535		6
	M126254	6		
ST510a		11		
	125646	11		

DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE / UPDATE

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
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Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

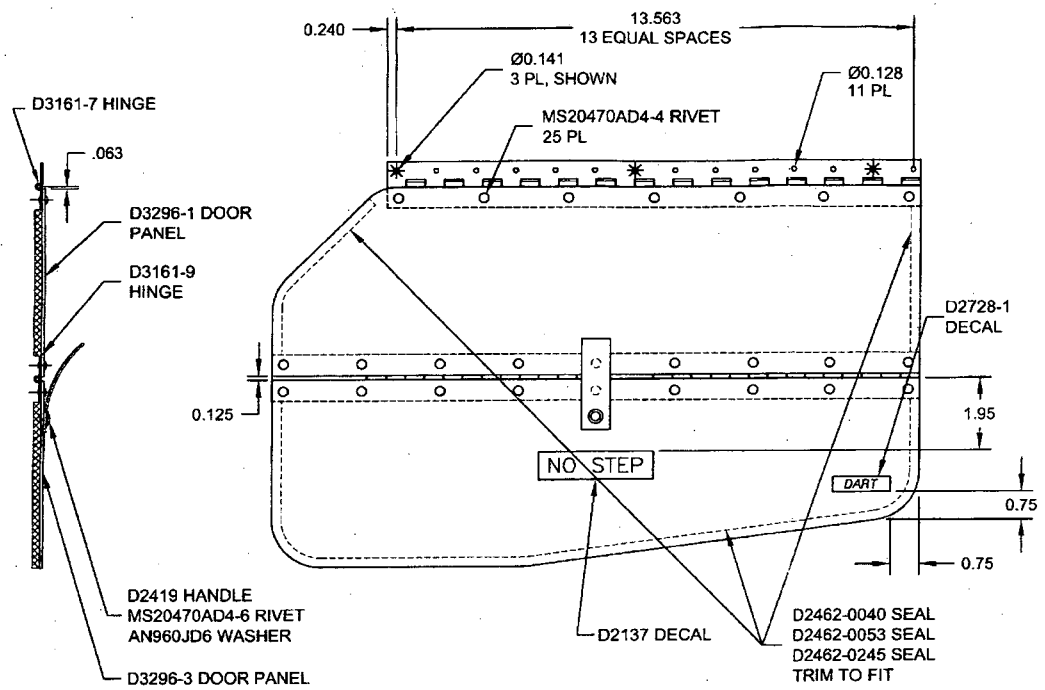
Landing Gear

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- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

QTY -041	PART NUMBER	DESCRIPTION
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



107996 MCJ
13-10-08
RELEASED
2012-11-21

D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.8 lbs
8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

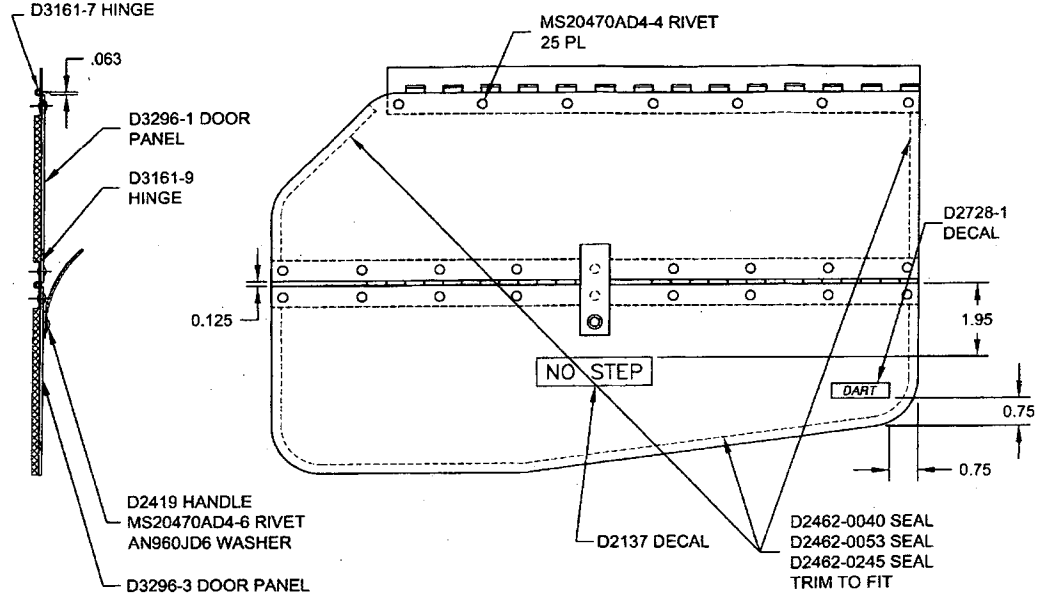
REV.	DESCRIPTION	BY	DATE
B	ADD D3296-041B. REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3296 SHEET 1 OF 3
APPROVED		TITLE SCALE
DE APPR.		DOOR ASSEMBLY NTS
DATE	12.11.15	

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107996

QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET



RELEASED
2012 -11- 21

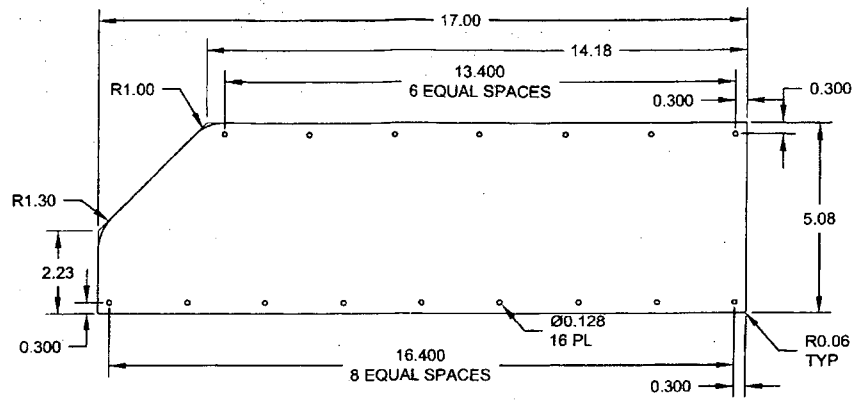
D3296-041B DOOR ASSEMBLY, BLANK

D3296-041B NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.8 lbs
8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

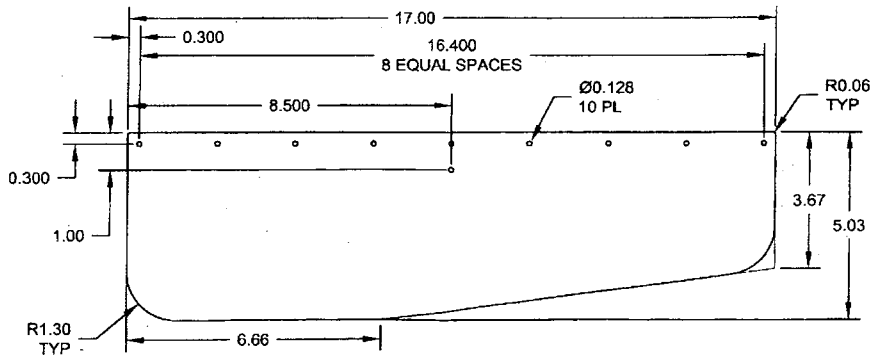
DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3296 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		DOOR ASSEMBLY NTS
DATE	12.11.15	

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D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

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2012 -11- 21

D3296-1/-3 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: D3296-1 = 0.52 lbs, D3296-3 = 0.50 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3296 SHEET 3 OF 3
APPROVED		TITLE SCALE
DE APPR.		DOOR ASSEMBLY NTS
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